



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3700-C-03

Job Sheet 194562



DAG
21
9-69

Part No: RBE350A94-3700-C-03

Job Qty: ~~12~~ **20** pcs

Part Name: Bolt



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/3/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-C Rev 6 IPP Rev A 18.01.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier Lead Time	
120	SL-154 - 1	12 pcs	6/14/19	6/14/19	0.00 3.00	SL-154 - 1	<i>[Signature]</i> 6/14/19
130	QC 2	12 pcs	6/14/19	6/14/19	0.00 0.00	QC 2 - 1	
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	
						QC 2 - 32	
						QC 2 - 33	<i>[Signature]</i> 6/14/19
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	



Container No: S206507



Part: RBE350A94-3700-C-03

Job No: 194562

Serial No/Batch: S206507

Revision: 6

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/18/19

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160 QC 8	12 pcs	6/14/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	m 19/08/18
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
170 Outsource - 12 - Black Oxide	12 pcs	6/14/19		GRO002-VC	10 LA 2019-08-19
180 Packaging 2-1 - Receive - B4B	12 pcs	6/14/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP AUG 28 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	

				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
190 QC 6	12 pcs	6/14/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	81
				QC 6 - 40	9-89
200 Packaging 3-1 - Stock - B4B	12 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	12 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 120 - 1-Machine as per folio FC750 FOLIO REV: <u>AA</u> DWG REV: <u>6</u> 2-Deburr Descriptions: 130 - (QC2- Inspect parts off machine FAI/FAIB) 160 - (QC8- Inspect parts - second check) 170 - Issue P/O; PO <u>44284</u> -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required 180 - (Receive & Inspect for Damage & Mat'l Certs) 190 - (QC6- All purchased or subcontracted products) 200 - (Identify as per dwg & Stock Location: _____) 210 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
92580A112	Grade B7 Threaded Rod, 5/8"-18 Thread Size, 3 Feet Long	3.7800 ft (.315 ea)	120-SL-154 - 1		<u>5092519</u>

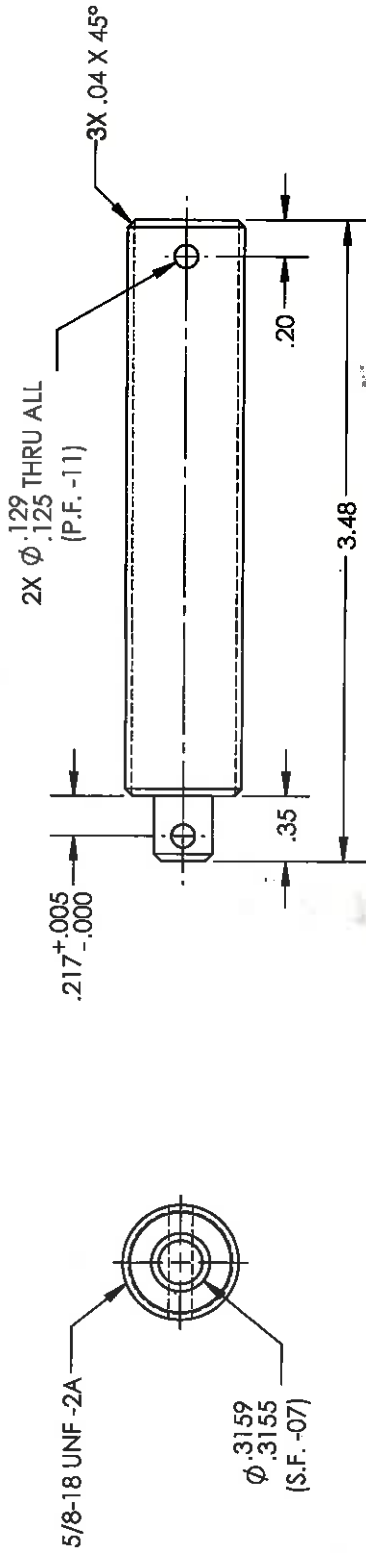
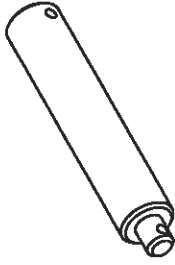
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-SL-154 - 1	92580A112	4	12	0
Part Specifications				
Specifications could not be found.				

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	15-0213	-03 CHD HOLE WAS Ø3.129 - .125, CHD DIM WAS Ø.315 S.F. -Ø7 IS Ø.3159 - .3150.	8/14/2015	RJC	JAG
6	16-0286	-03 CHD DIM WAS Ø.3159/.3150 IS Ø.3159/.3155 (S.F. -Ø7), WAS 217 IS .217 +.005/0.000, WAS 2X Ø.129/.125 THRU IS 2X Ø.129/.125 THRU ALL (P.F. -11), ADDED FINISH SPEC QMST-6.2.2, B.O. REV'D.	2/28/2017	RJC	SM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194562
19-05



③

ALL THREAD

		SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE		TITLE
DWS NO.		RBE350A94-3700-C-03		REV 6
MATL 87 STEEL		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS $\pm 1/16$		.XXX $\pm .005$.XX $\pm .01$.X $\pm .1$
HEAT TREAT FINISH BLACK OXIDE		ANGLES $\pm 8^\circ$ SURFACES $\pm 125 \sqrt{\text{A}}$		1. BREAK ALL SHARP EDGES $.015 \times .45^\circ$ OR .01R
SPEC QMS-6.2.2, B.O. REV D		2. DIMENSIONAL LIMITS APPLY AFTER PLATING		3. INTERPRET DIM AND TOL PER ASHIE Y14.9M-2009
DRAWN BY: CLOUGH		DUERFELDT		USED ON MODEL
CHECKED:		ANDERSON		EUROCOPTER AS350/355
COPS APPR:		LINDSAY		SHEET 4 OF 7
QA APPR:		MACKOVJAK		DATE 8/21/2012
APPROVED:		1:1		SCALE

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____		DISPOSITION		DEPARTMENT/PROCESS		Engineering			
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐			
Date:		Sequence #:		QTY Affected:		MRB (QS1042)			
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Operator ☐		Pressure/Forced ☐		Contamination ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Folio/Program ☐		Outside Tolerance ☐	
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Grain Direction ☐		Drawing ☐	
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Finish ☐	
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Product Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Out of Sequence ☐		Misread ☐	
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐		Off-set/Set-up ☐			
Human Factors ☐		Other/Details:							
				Completed By					
				Lead hand / Supervisor					
				QC / QA Coordinator					

RBE350A94-3700-C-03 INSPECTION SHEET

reactor line	1,000 S
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Measured by: <i>[Signature]</i>	Checked by: <i>[Signature]</i>
Date: <i>19/08/19</i>	Date: <i>19/08/18</i>

Engineering Approval: (if necessary)		Date:
--	--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044284**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044284

PO Date: 8/19/19

Due Date: 8/27/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-08-20

Items

Line	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194529	RBE350A93-3312-03-5	Seat -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	8/27/19	18 pcs	0 pcs	18 pcs	\$1.35/pcs	\$24.30
2	199074	RBST2120-11	Primary Seat -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/27/19	5 pcs	0 pcs	5 pcs	\$1.48/pcs	\$7.40
3	194528	RBE350A93-3312-03-3	Remover / Installer -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	8/27/19	12 pcs	0 pcs	12 pcs	\$1.35/pcs	\$16.20



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PURCHASE ORDER
POHB044284



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	194530	RBE350A93-3312-03-7	Washer -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	8/27/19	18 pcs	0 pcs	18 pcs	\$1.35/pcs	\$24.30
AUG 27 2019 \$206018 DP											
5	194562	RBE350A94-3700-C-03	Bolt -Issue P/O; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/27/19	20 pcs	0 pcs	20 pcs	\$1.55/pcs	\$31.00
AUG 28 2019 \$206507 DP											
6	196318	RBE350A93-3303-02-5	Extractor Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/27/19	25 pcs	0 pcs	25 pcs	\$1.05/pcs	\$26.25
AUG 27 2019 \$200339 DP											
Grand Total:										\$129.45	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/20/19 4:25 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021664-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.grouppaltech.com

Bon de Livraison / Packing Slip

021664 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
28-Aug-2019		Jigar Patel		POHB044284				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3312-03-5 Rev.	RBE350A93-3312-03-5 OXIDE BLACK [OXIDE BLACK] AS PER MIL-C-13964, CLASS - 1 OR MIL-C-16173 GRADE - 4	BLACK-OXIDE CH	18	18	0	0	0
5	RBE350A94-3700-C-03 Rev.	RBE350A94-3700-C-03 OXIDE BLACK [OXIDE BLACK] AS PER MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	20	20	0	0	0

RECEIVED
 AUG 28 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

J. J. A. Y.

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.